

Date: Tuesday, 29/04/2008 10:57:19 AM
 User: Melanie Fauteux

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: TUBE
Job Number	: 38884		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D37693
This Issue	: 29/04/2008 S.O. No. :	Drawing Number	: PROTOTYPE
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: A
Previous Run	: 38880	Material	:
Written By	: <u>W</u>	Due Date	: 16/05/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	:		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3769 REV A

2.0	M6061T6T1000W065	6061T6 TUBE
-----	------------------	-------------



M107950
2 x 15.180"



ml 08/05/09
FF 08-05-22

Comment: Qty.: 1.3200 f(s)/Unit Total: 5.2800 f(s)
6061T6 TUBE

m106734 x2

ml 08/05/09

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

UP 08.05.09 / 08/05/09 (P)
S 08/05/22

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

ACID ETCH AND ALODINE PER QSI.005

RP/FL 08/05/12 (P)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/12 (P)

Date: Tuesday, 29/04/2008 10:57:19 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: TUBE

Job Number: 38884

Part Number: D37693

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

Pat 01.05.29

CHARGE TO JOB #00196

7.0

QC21

FINAL INSPECTION/W/O RELEASE



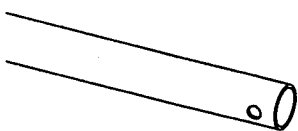
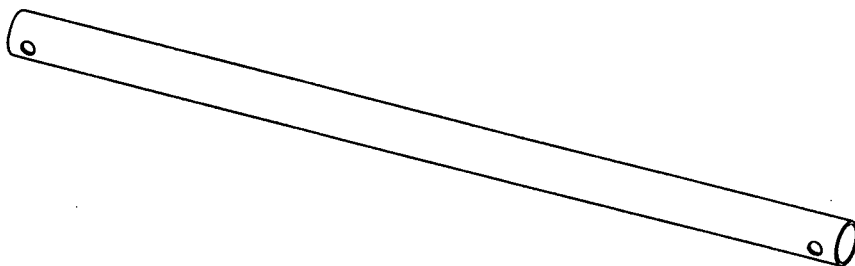
Comment: FINAL INSPECTION/W/O RELEASE

4
A080529 Prototype

Job Completion



u 08/06/11

**69-3 TUBE****D3769-5 TUBE**

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

9708.04.23

SPEC. M6061T6T1.000W.065)

REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS			
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3769	SHEET 1 OF	
APPROVED		TITLE	SCA	
DE APPR.		TUBE	N	
DATE	08.03.26		COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8

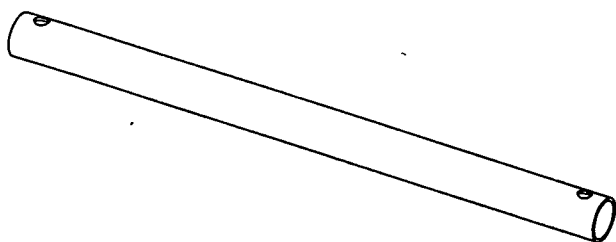
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6

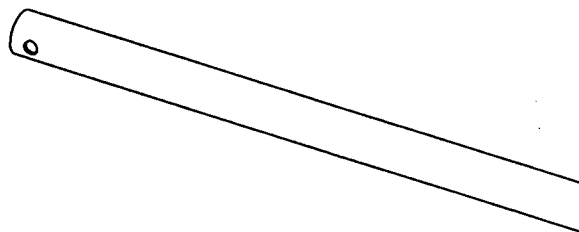
5

D

C



D3769-1 TUBE



D3769-3 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.00C)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

8

7

6

Receiving Report

Date: 08/01/08

Batch No: M 106739

Supplier Marmon Keystone

Dart PIO: 5373

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection ☒ 08/07/08 N/A ☒
Work Order ☒ N/A ☒

Discrepancies

Discrepancies							
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments	

Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin:

Date 08/01/08
Received/Costing RCV 6668
Initial CF

Location _____

FORMS: Purchasing approved | arch\RECREPORT R / D

Energy Surcharge			12.20
<div> <div>COPIES OF ORIGINALS</div> <div> <div>GST</div> <div>HST</div> </div> </div>			2.95

ORIGINAL INVOICE / FACTURE ORIGINALE

**TERMS: NET 30 DAYS
PLUS 2% PER MONTH ON
ALL OVERDUE ACCOUNTS.**

**TERMES: NET 30 JOURS
PLUS 2% PAR MOIS
SUR COMPTE PASSÉ DÜ.**

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES
RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

G.S.T. /HST T.P.S.	2.95
PROVINCIAL TAX TAXE PROVINCIALE	.00

61.95

**PAYMENT OF THIS INVOICE IS DUE BY
LE RÈGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE**

02/06/2008

Receiving Report

Date: 8/5/6
 Supplier: MALMUR

Batch No: M1-7950
 Dart P/O: 6269

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☒
 QC6 Inspection: 6/25/08 N/A ☒
 Work Order: _____ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

[Signature]

Production/Admin:

Date: 08/05/08
 Received/Costing: R/P 7822
 Initial: CL

Location _____

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

TERMINES, 15 JOURS
 15 JOURS PAR MOIS
 SUR COMPTES PASSE C0

TERMINES, 15 JOURS
 15 JOURS PAR MOIS
 SUR COMPTES PASSE C0

FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
 POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES
 RENSEIGNEMENTS A L'ENDOS DE LA FACTURE ORIGINALE.

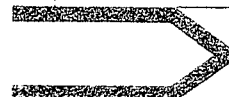
G.S.T. /HST 18.02
 T.P.S.

PROVINCIAL TAX
 TAXE PROVINCIALE .00

378.38

AMOUNT OF THIS INVOICE IS DUE BY
 MONTANT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

06/04/2008



FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE
 M/K OR:
 C.P.O.:
 C PART:

INIT.:

To:

OR. REF:
 SLSPRS:

KAISER

ALUMINUM

FABRICATED PRODUCTS

KAISER ALUMINUM
 FABRICATED PRODUCTS
 6573 W. WILLIS ROAD
 CHANDLER, AZ 85226

CERTIFIED TEST REPORT

<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER: 80-33503		CUSTOMER PART NUMBER: AT/1.065/734		PRODUCT DESCRIPTION: Seamless Tube	
KAISER ORDER NUMBER: 200438	LINE ITEM: 005	SHIP DATE: 11/27/2007	KAISER LOT NUMBER: F00000606	ALLOY: 6061	TEMPER: T6
WEIGHT SHIPPED: 331.000 LB	QUANTITY: 123.000 PCS	BL NUMBER: 200274	ODW/DART/THKS: 	WIDTH: 	LENGTH: 12.000 FT
SHIP TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA			SOLD TO: MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONTRACT#	REMARK
F00000606	0001	1	46.5	42.6	17.0	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Er	La	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.30	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22452	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Plant Serial: 00000266

Kaiser Order Number: 200438

Line Item: 005

Page 1 of 2

FEB 06 2008 13:10

AT 1.065 734

Q.C. REVIEWED

PAGE.02

18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 1450641437

3/2008 From: MARMON/KEYSTONE

To:

OR. REF:

SLSPRS:

K OR:

C.P.O.:

C PART:

INIT.:

KAISER ALUMINUM

FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6673 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round @
AMS-4082N ASTM-B210-04 WW-T-700/5F
WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR
CANCELLED: MIL-T-7081, WW-T-700F/QEN, WW-T-700/2E, WW-T-700/3F,
WW-T-700/4F, WW-T-700/5E, WW-T-700/6F, WW-T-700/7E.
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204
COMPLIES TO DIN EN 10204 JAN 2005

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file subject to examination.

Wilfredo A. de la Cruz, Sr. Metallurgical Engineer

Plant Serial: 00000264

Kaiser Order Number: 200438

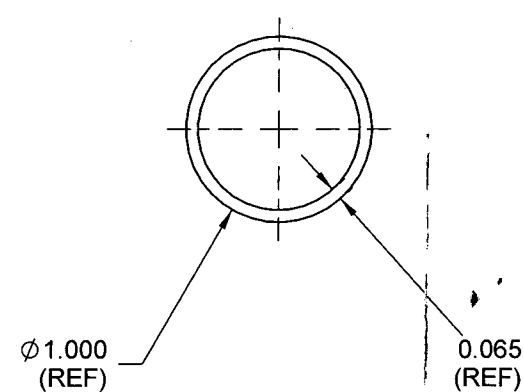
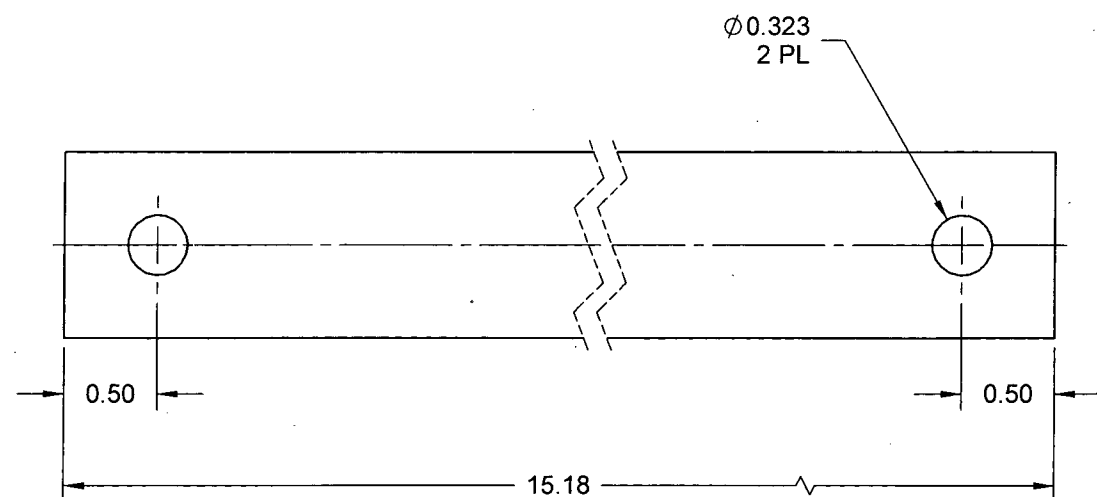
Line Item: 005

Page 2 of 2

FEB 06 2008 13:11

PAGE.03

** TOTAL PAGE.03 **



D3769-3 TUBE

PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 08.04.23

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3769	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TUBE	1:1
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	